

5/25

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23590
<b>Description:</b> Long Pin Bracket		<b>Part Number:</b>	D3330-11
Dwg: D3330 Rev. <i>10</i> <i>21/05-01-17</i>		<b>Qty:</b>	15
PAGE 9 RF05.01.17		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>KJ</i>	05.06.16	15
2	MV	Cut blanks: 2.500" x 1.000" x <del>0.030</del> <i>5.00"</i> long (+/-0.030) Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel (M1010-B2.500x01.000) Identify for D3330-11 Batch: <i>M17668</i>	<i>CP</i>	05/06/17	15
3	MV	Machine as per Folio FA479 and Dwg D3330 Identify as D3330-11	<i>J.L</i>	05/06/18	15
4	QC2	Inspect parts as they come off the CNC machine	<i>J.L</i>	05/06/18	15
5	QC8	Second check	<i>FL</i>	05.06.18	15
6	MV	Deburr	<i>J.L</i>	05/06/18	15
7	QC5	Inspect work to Step 6	<i>FL</i>	05.06.18	15
8	ST	Identify and Stock	<i>CPL</i>	05/06/20	15
9	AC	Cost / part: <i>21.73</i>	<i>AR</i>	05/06/20	15
10	DC	Close W/O <i>20.31</i> Inspect Level 21	<i>KJ</i>	05.06.28	15

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED  
*21/05-01-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>23590</b>
<b>Description:</b> Long Pin Bracket		<b>Part Number:</b>	<b>D3330-11</b>
<b>Inspection Dwg:</b> D3330 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                 
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+/-0.030	5.00	✓			
4.625	+/-0.010	4.635	✓			
0.260	+/-0.010	0.262	✓			
Ø0.594	+0.005/-0.000	0.594	✓			
0.875	+/-0.010	0.870	✓			
0.837	+/-0.010	0.844	✓			
0.700	+/-0.010	0.696	✓			
0.500	+/-0.010	0.501	✓			
2.25	+/-0.030	2.251	✓			
0.950	+/-0.010	0.954	✓			
Ø0.531	+0.005/-0.000	0.533	✓			
Ø0.348	+0.005/-0.000	0.348	✓			
Ø0.516	+0.005/-0.000	0.516	✓			
0.467	+/-0.010	0.466	✓			
1.250	+/-0.010	1.250	✓			
1.00	+/-0.030	0.997	✓			
0.10 x 45°	+/-0.5°	0.994 x 45°	✓			

<b>Measured by:</b> <i>ED</i> <b>Date:</b> 05/06/17	<b>Audited by:</b> <i>DC</i> <b>Date:</b> 05/06/17	<b>Prototype Approval:</b> N/A <b>Date:</b> N/A
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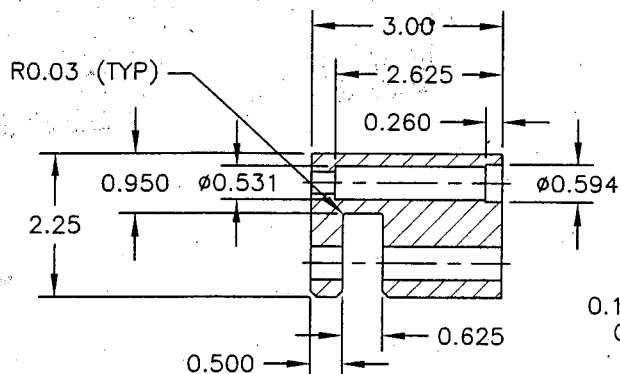
Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED

*[Signature]* 05.05.11

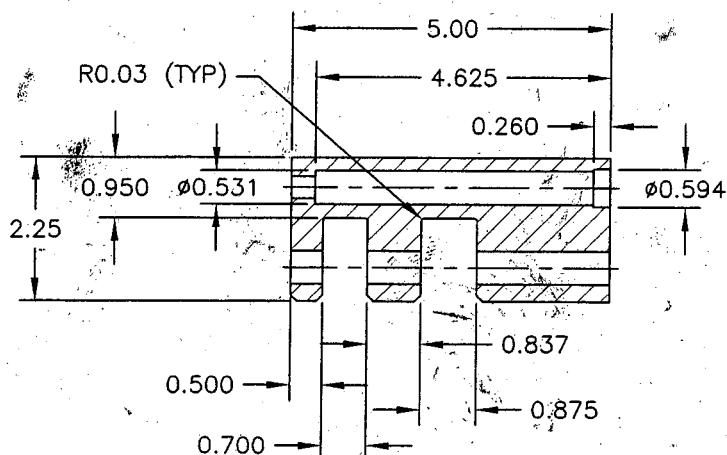
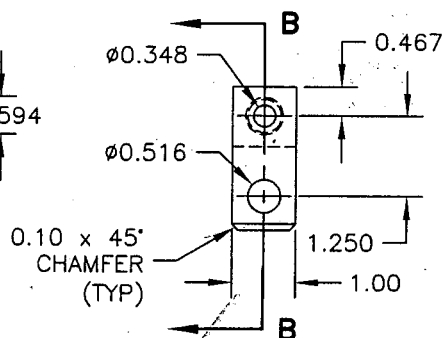


DESIGN A2	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3330	REV. B SHEET 9 OF 9
DATE 05.02.26	TITLE FRAME WELDMENT		SCALE 1:3



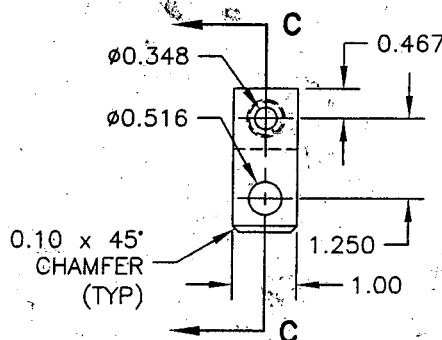
**SECTION B-B**

**D3330-13 SHORT PIN BRACKET**



**SECTION C-C**

**D3330-11 LONG PIN BRACKET**



**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x0.2.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
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UNCONTROLLED COPY  
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WITHOUT NOTICE

WORK ORDER

NO. 23590

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 16, 2005  
02:11 pm

Work Order No : 0023590  
Project Name : D3330-11  
Project For : WK525  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3330-11  
Description : Long Pin Bracket  
Manufactured : Yes  
Amount Req'd : 15  
Amount Done : 0  
Start Date : 06-16-05  
Est Finish Date : 06-24-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00